

KOBELCO

FAMILIARC™

MX-A70C6LF

Highly efficient metal-cored wire for carbon steel



High deposition rate with excellent weldability is created by a wide spray-transfer range

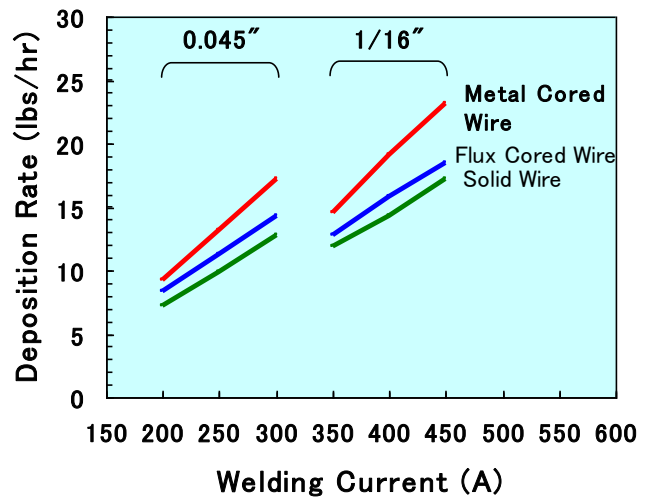
Code Data

AWS/ASME A5.18 E70C-6M

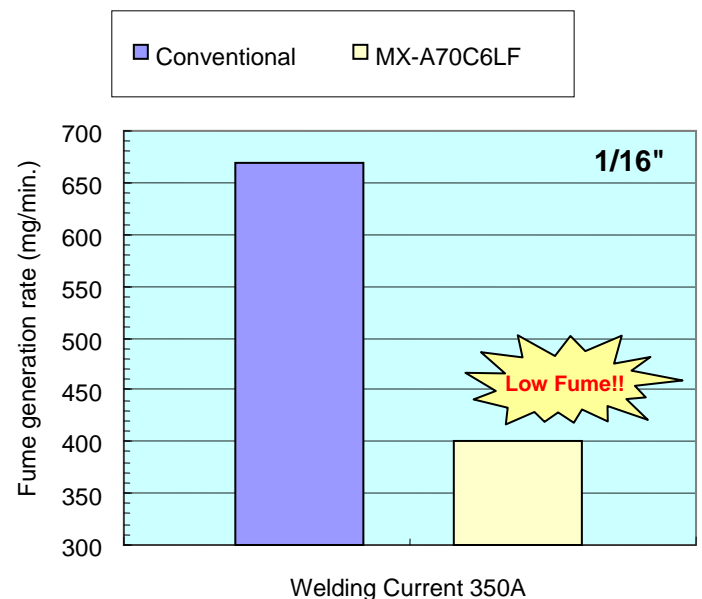
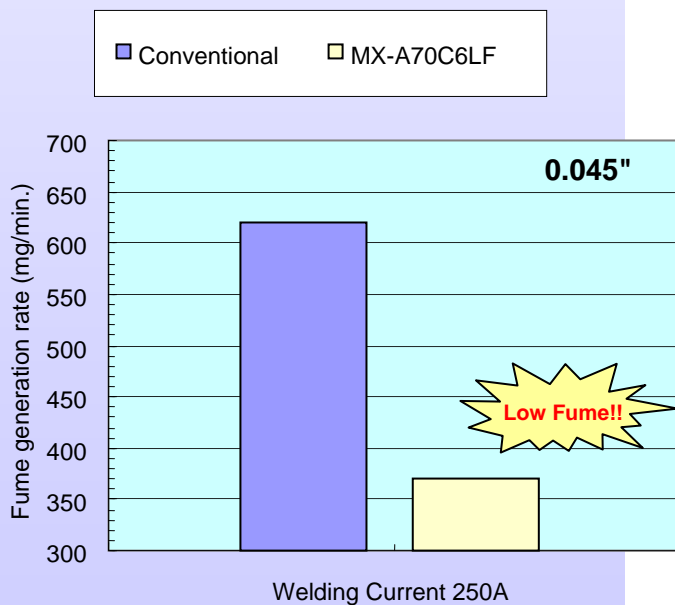
CWB W48-06 E492C-6M-H4

Outstanding Features

- MX-A70C6LF has lower fume and spatter generation than conventional metal cored wire.
- Its cored metal powder has higher deposition rates than solid wire.



Typical deposition rate of welding consumables



Fume generation (90%Ar-10%CO₂)

Typical chemistry of weld metal and diffusible hydrogen content (Wire size 1/16")

Shielding gas	C	Si	Mn	P	S	Diffusible hydrogen content (ml/100g)
80%Ar-20%CO ₂	0.04	0.79	1.62	0.008	0.009	2.9
95%Ar-5%CO ₂	0.04	0.85	1.69	0.007	0.010	3.5

Gas chromatography method (AWS A4.3)

Typical mechanical property of weld metal (Wire size 1/16" 340A)

Shielding gas	0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
				-50 °F	-20 °F
80%Ar-20%CO ₂	64,700	80,400	34	58*	96
95%Ar-5%CO ₂	66,600	81,900	34	-	101

* Wire size 0.045" 280A

Recommended welding condition

Wire size (in.)	Wire feeding speed (in./min)	Current (A)	Voltage (V)	Deposition rate (lbs/hr)	Wire stick out (in.)
0.045	300	200	28-31	7.5	5/8" -3/4"
	375	240	29-33	9.5	
	435	280	30-34	11.0	
	530	320	32-36	13.5	
	620	360	33-37	15.5	
0.052	250	230	27-29	8.5	3/4" -1"
	300	270	28-32	10.5	
	400	320	30-34	14.0	
	460	370	31-36	16.0	
	545	420	32-37	19.0	
1/16	165	260	27-29	7.5	3/4" -1"
	245	320	28-33	11.5	
	350	380	29-35	17.0	
	415	440	30-36	20.0	
	490	500	31-37	24.0	



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

July 2018